

5/10

SPUT

DART AEROSPACE LTD	Work Order:	22478 A
Description: Battery Lock Casing	Part Number:	D3393-1
Dwg: D3393 Rev. A page 2	Qty:	40 22
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	DA	05.02.21	40
2	MV	Cut blank: 1.500" x 1.500" x 3.125" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B1.500x01.500) Identify for D3393-1 Batch: M10415	SD	05.02.22	40
3	MV	Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1	SD	05.02.23	40
4	QC2	Inspect parts as they come off the CNC machine	SD	05.02.23	40
5	QC8	Second check	CE	05.02.23	40
6	MV	Deburr / Tumble	SD	05.02.23	40
7	QC5	Inspect work to Step 6	ML	05.02.23	40
8	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05.02.23	40
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	ML	05.02.24	22
10	QC3	Inspect Powder Coat	ML	05.02.24	22
11	ST	Identify and Stock	ML	05.02.24	22
12	AC	Cost / part 9.56	ML	05.02.25	22
13	DC	Close W/O 9.56 Inspect Level 21	DA	05.03.03	22

Rev	Date	Change	Revised By	Approved
A	05.02.18	New issue	KJ/JLM	

RELEASED
05.02.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.02.22	3	22 scrap, prototypes, design was changed after production was started.	<i>[Signature]</i>	destroy & replace	<i>[Signature]</i> 05.03.22	<i>[Signature]</i> 05.03.22	<i>[Signature]</i> 05.03.22	<i>[Signature]</i> 05.03.22

Part No: D3393-1 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 05/03/02

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 21, 2005
02:21 pm

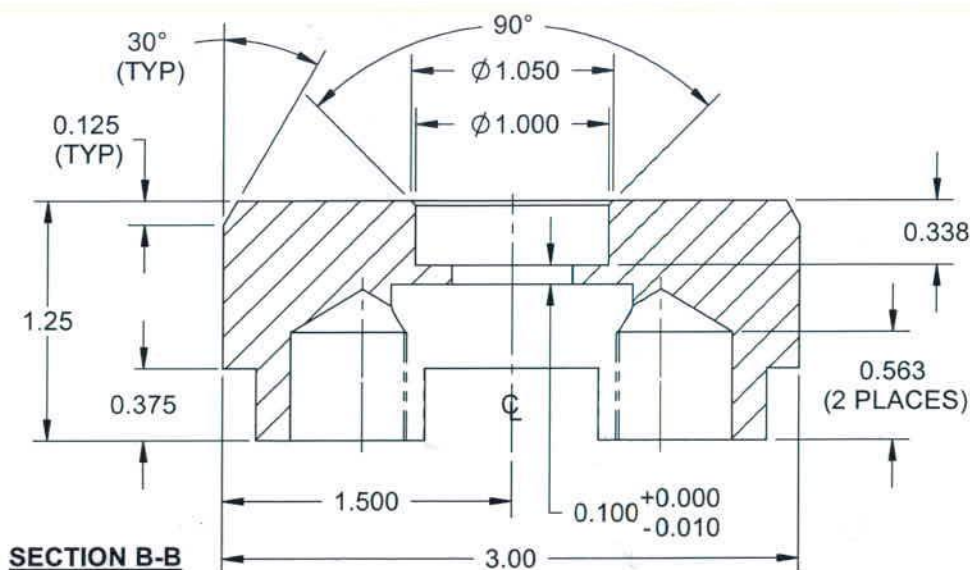
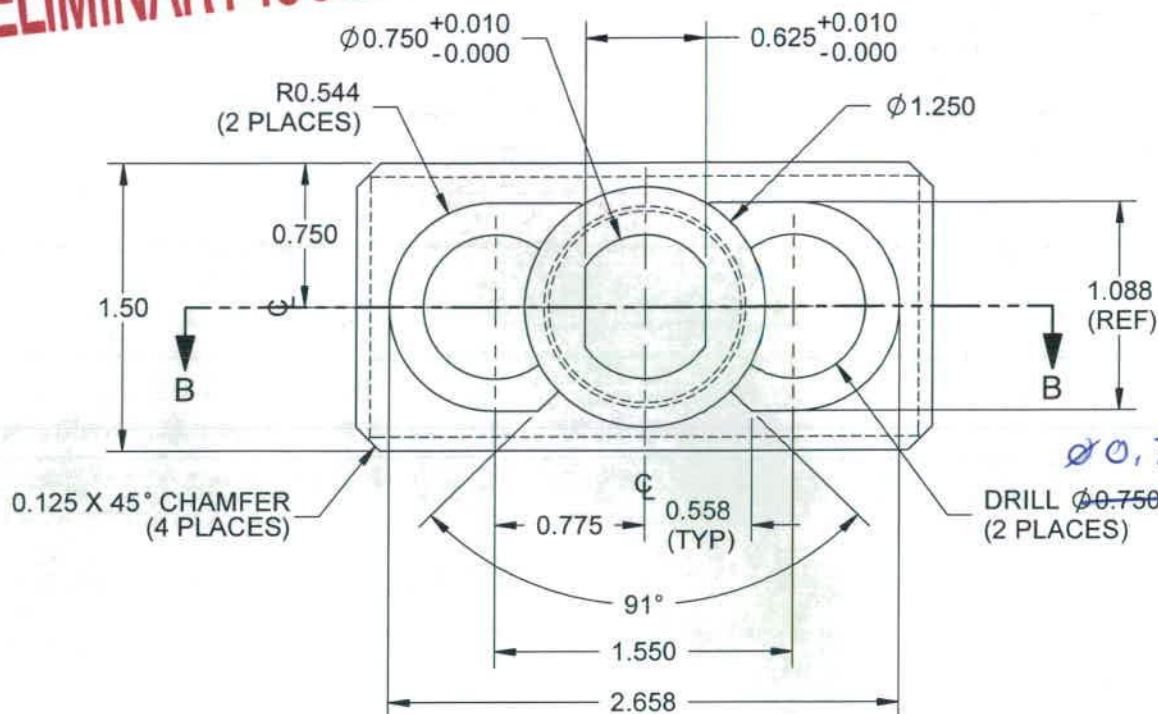
Work Order No : 0022478
Project Name : D3393-1
Project For : WK510
Work Order Type : Main
Main WO Number :
House Part Number : D3393-1
Description : Battery Lock Casing
Manufactured : Yes
Amount Req'd : 40
Amount Done : 0
Start Date : 02-17-05
Est Finish Date : 02-28-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



D3393-1 CASING

NOTES:

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PRELIMINARY ISSUE

DART AEROSPACE LTD		Work Order: 22478
Description: Battery Lock		Part Number: 03393-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .750		.760	✓			
.625		.635	✓			
Ø 1.230		1.240	✓			
1.088		1.089	✓			
Ø .734		.735	✓			
2.658		2.659	✓			
1.550		1.551	✓			
.775						Cannot measure
.125 X 45°		.127 X 45°	✓			
1.50		1.490	✓			
.750		.744	✓			
Ø 1.030		1.050	✓			
Ø 1.000		0.990	✓			
.338		.339	✓			
.563		0.571	✓			
.100	+ .000 - .010	0.099	✓			
3.00		3.007	✓			
1.500		1.500	✓			
.375		.376	✓			
1.25		1.240	✓			
.125		.130	✓			
30°		30°	✓			

Measured by: SD	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 05.02.22	Date: 05.02.22	Date: 05.02.23
Rev A	Date	Change
		New Issue
	Revised by	Approved
	KJ/JLM	

